

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003798**Date Inspected:** 03-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih-Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower skin plates OBG side, bottom and deck**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**Tower bay 1**

QA performed 10% verification Ultrasonic Testing (UT) R1 repair on tower skin plate joint NSD1-076A/H 58 A/B. The repaired area appeared to be in conformance with AWS D1.5 2002 and the contract documents.

QA noted that ZPMC UT technicians have rejected tower skin plate weld joint# ESD1-SA298A/G-5A/B

**OBG assembly bay 2**

QA observed ZPMC personnel apparently gearing up to start tack welding diaphragm plates to deck panels DP-079-001, DP-078-001 and DP-077-001. This would be a direct violation of state letter no. 05.03.01-002561, Temporary Suspension of Diaphragm Plate to Deck Plate Assembly, dated August 15, 2008. As of the end of this shift ZPMC did not tack these diaphragms in place. An incident report will be submitted by Caltrans QA if ZPMC commences with the fit up and tack welding of these diaphragms.

QA performed 10% verification UT on floor beam joints SSD17-PP027-013 and SSD17-PP027-088. Both welds appeared to conform with AWS D1.5 2002 and the contract documents.

Other general observations include ZPMC personnel fitting and welding OBG temporary support columns,

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grinding and weld bevel prep on various OBG components.

### Summary of Conversations:

Only general conversation was held between QA and QC on this day.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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